

Date: Monday, 08/06/2009 1:12:00 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEB		
Job Number	: 48412					
Estimate Number	: 10195					
P.O. Number	:			Part Number	: D21741	
This Issue	: 08/06/2009		S.O. No.	: D2174-1 REV E		
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	: 37848			Drawing Revision	: E	
Written By	:			Material	:	
Checked & Approved By	: JUD 09.06.08			Due Date	: 15/06/2009	
Comment	: Est C 04.06.09 Reformat KJ/RF Est Rev:D As per Rev E 06-11-22 JLM			Qty:	10	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S063	2024-T3 .063 sheet	
		Comment: Qty.: 0.4958 sf(s)/Unit Total : 4.9581 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063)	Batch: 10980 189-69
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2174 Dwg Rev: E 18 9-6-9 Prog Rev: E	
		2-Deburr if necessary	18 9-6-9
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	18 9-6-9
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE Deburr Stack	MJS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



S
08/06/10 (xx)

Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(1)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 08-06-11

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

09-06-11

(X)(1)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

28 09/06/11

(11)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



09/06/11 (11)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

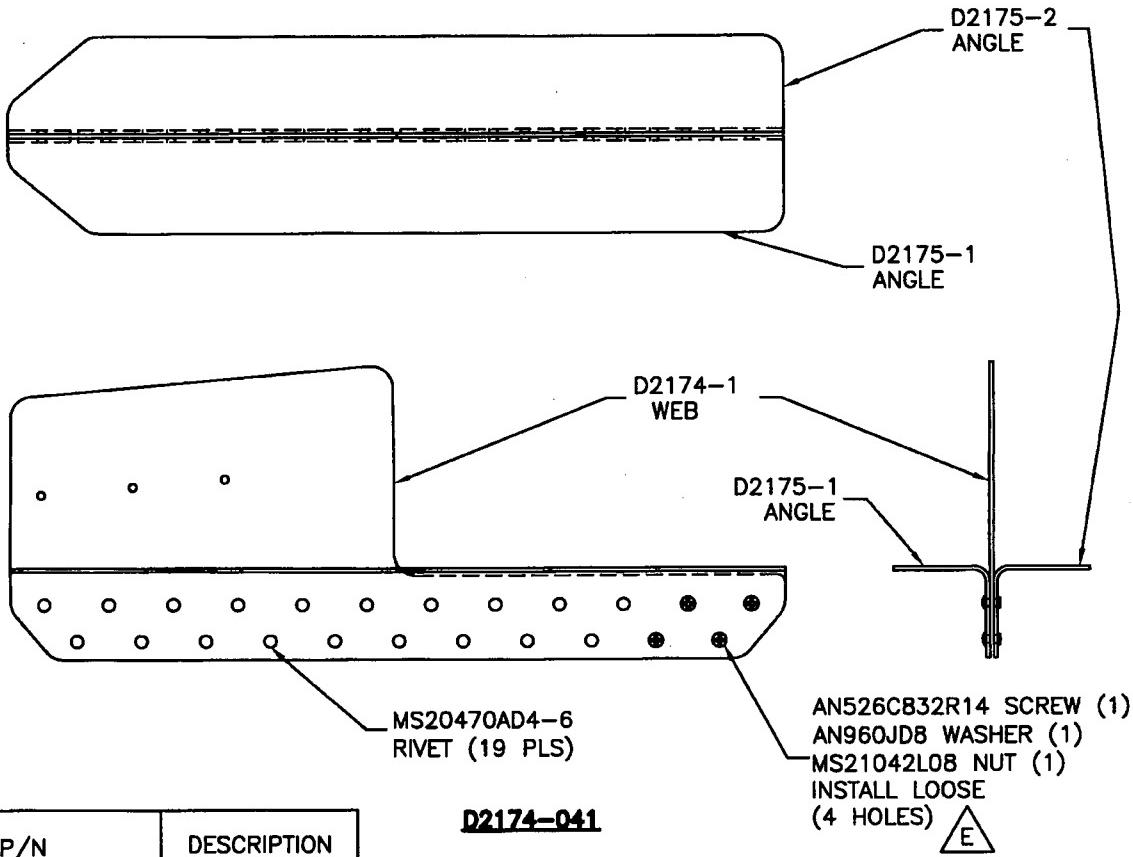
DART AEROSPACE LTD	Work Order:	48412
Description: Web	Part Number:	D2174-1
Inspection Dwg: D2174	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>B</u>	Audited by:	<u>J</u>	Prototype Approval:	N/A
Date:	9-6-9	Date:	09/06/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	JL
B	07.04.02	Ø0.172 dimension added	KJ/JLM	JL

DART

QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

SHIPPING COPY
RETURN TO
ENGINEERING
(INC) CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48812

RELEASED
06-10-13

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

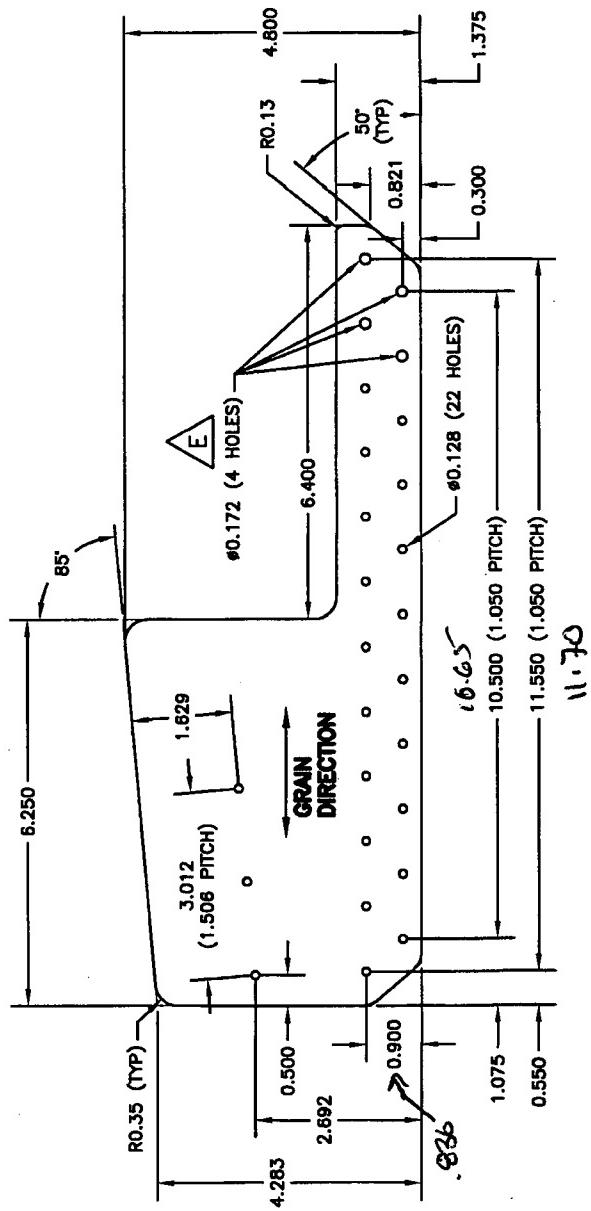
DESIGN RF	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D2174		
DATE 06.09.25	TITLE WEB ASSEMBLY			SCALE 1:3
A	95.10.25	NEW ISSUE		
B	96.01.18	RE-DRAWN		
C	00.09.11	UPDATE FINISH SPEC.		
D	04.06.03	RE-DESIGN		
E	06.09.25	INC 4 HOLES TO #0.172; CHG HARDWARE		

DART

DESIGN RF	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D2174	REV. E SHEET 2 OF 2
DATE 06.09.25		TITLE WEB	SCALE 1:3

12.62

RELEASED
06.10.3



D2174-1

NOTES:
 (1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
 (2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 (3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 (4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 (5) ALL DIMENSION ARE IN INCHES
 COPY
 TURN TO
 ENGINEERING
 SOLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. *48472*

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